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Backward extrusion process for inner profiles

Abstract

A process of producing an inner profile 18 in a tube or hollow profile 11 with the following characteristics:

inserting the tube or hollow profile 11 into a supporting sleeve 12, with a first tube end 19 being axially supported; placing a pressure-loaded annular die 16 on to the other tube end 20;

pressing a forming die 15 with an outer profile into the tube or hollow profile 11 from the latter tube end 20 for producing the inner profile 18;

allowing a return of the annular die 16 under a pressure load in the opposite direction of that of pressing in the forming die 15.

Figure 1